
Page 1

Accept

[illegible]

Setup Start

[illegible]

Stop

[illegible]**Cust Item ID:**

Start Date: 6/27/2011 **Start Qty:** 12.00

Required Date: 8/5/2011 **Req'd Qty:** 12.00

Customer:

Reference:

Run Start

Approvals: Process Plan: CMF

Date: 11-06-27 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

[illegible]

100	FLOW WATER JET	0.00	
Waterjet	Memo	0.00	B11-7-4
FLOW CNC Waterjet	1-Cut as per Dwg D3535 <input type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2-Deburr if necessary		(13)
304 . 040			
110	QC2- Inspect parts off machine FAI/FAIB	0.00	
QC	Memo	0.00	B11-7-24
Quality Control			
120	QC8- Inspect parts - second check	0.00	
QC	Memo	0.00	Swed 7/04
Quality Control			(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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NOTE: Date & initial all entries

Work Order ID 71284

Monday, June 27, 2011 10:48:46 AM



Page 3

Item ID: D3535-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 6/27/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

B 6 11-7-6

170

Identify as per dwg & Stock Location FD-19

0.00



Packaging

Memo

0.00

Packaging

B 6 11-7-6

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/06

ME

11-07-06

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NOTE: Date & initial all entries

Picklist Print

Monday, June 27, 2011 10:48:40 AM

Page 1

Work Order ID: 71284



Parent Item: D3535-11



Parent Item Name: Wearshoe

Start Date: 6/27/2011

Required Date: 8/5/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

217.6630

0.7015

8.861053

9.5



1811-7-4

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

217.663

116623

0.2

117550

9.363

117933

208.1

117933

(13)

W/O:		WORK ORDER CHANGES					
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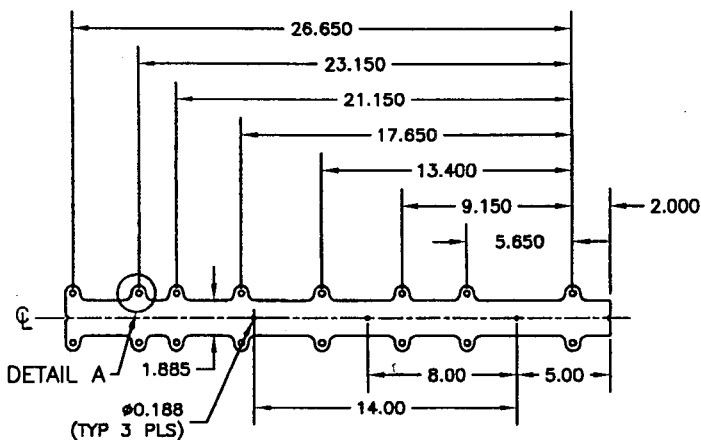
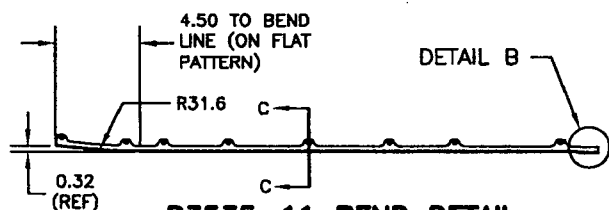
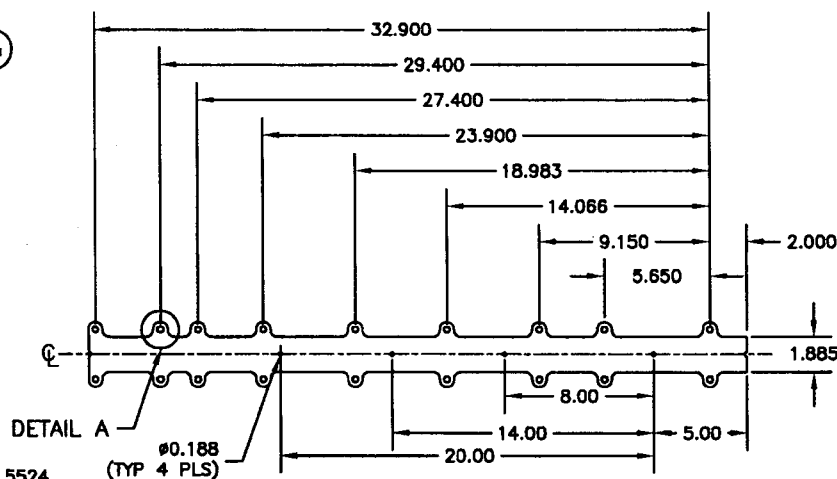
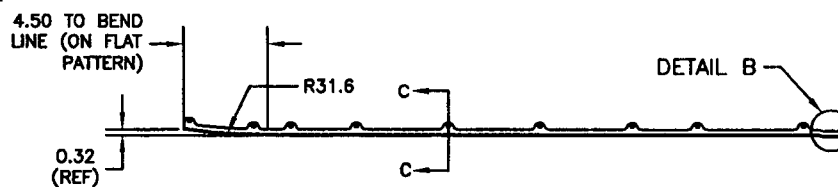
NOTE: Date & initial all entries

DART

RELEASED

07.04.24

#71284

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
PH	PH	D3535	SHEET 1 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		

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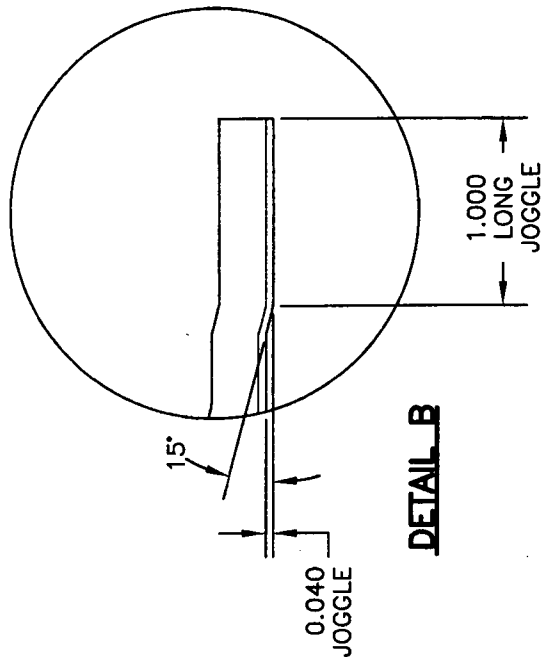
NOTE: Date & initial all entries



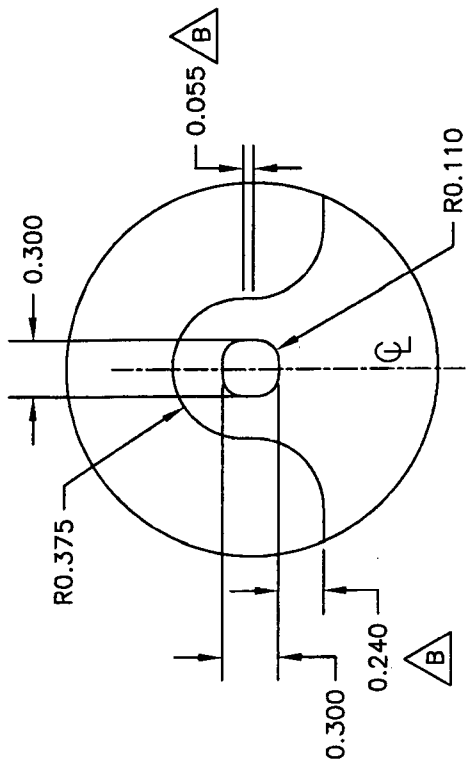
DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED
07.01.24 *[Signature]*

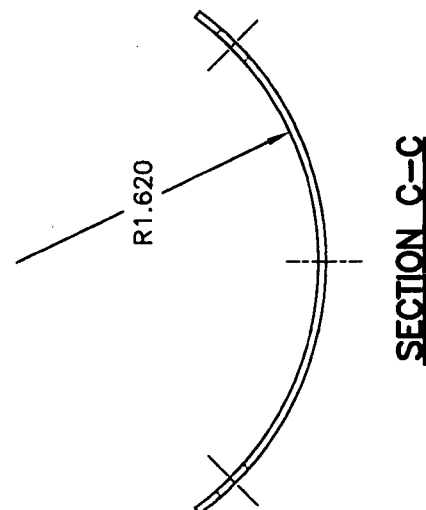
hscilt



DETAIL B



DETAIL A



SECTION C-C

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